

Work Order ID 62751

Thursday, October 07, 2010 3:09:29 PM

Page 1

Item ID: D2842-042

Accept

Setup Start

Revision ID:

Stop

Item Name: Step Assembly RH, 206 Float

Start Date: 10/7/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2842

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842
2-Drill D2842-1 using Jig DT8272 as per Dwg D2842
3-Deburr and bevel ends for welding

105



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

110



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch 1108436
Large Fab 1114877

0.00

Memo

0.00

1-Weld one end cap and (2) lugs as per Dwg D2842
2-Grind end cap weld flush

10.11.02

4

10.11.03

4

10.11.04

4

See PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

4 0 BE 10/11/09

130

~~QC9~~ Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Sidulus

(4/21)

Pto →

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo





0.00

Hand Finishing

10-11-09

4 0

Dart Aerospace Ltd

W/O: 62751		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		Perm. change						
16/11/09	# 130 105	change inspection level to QC6				 16/11/11	S 10/11/09	
10/11/11	170	QC9 → QC10 (NKT cap is a ground; not structural/weld) perm change		10.11.16		 10/11/11	 10/11/11	

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4. PR 10-11-9

160

Weld per dwg A/R Aluminum rod Batch: MP28436 0.00

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Remove alodine prior to welding.
Weld end cap as per Dwg D2842.
2-Grind end cap weld flush.

10.11.10

4 P

170

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

4 P BERG

W/O:		WORK ORDER CHANGES					
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Required Date:	10/15/2010	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  QC Quality Control	<i>FS</i> QC5 Inspect part completeness to step on W/O Memo	0.00 0.00		<i>Scrubber</i>		<i>(49 RH)</i>			<i>[Signature]</i>
185  HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo ✓***Touch up step with alodine per qsi 005 prior to powder coat***	0.00 0.00		<i>=> M 10/11/11</i>		<i>(x4 RM)</i>			<i>[Signature]</i>
190  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: OVEN TEMPERATURE: FINISH TIME:	0.00 0.00		<i>M115291</i> <i>8:35</i> <i>320°</i> <i>9/10.</i>					<i>HRH 10-11-15</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/11/09	# 320 180	Perm. Chan. chang inspection level to A QCB N/A					10/11/09	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries






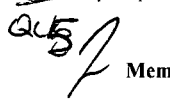

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Required Date:	10/15/2010	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200  QC Quality Control	QC3 Inspect Part Finish  Memo	0.00 0.00	1014115			x4	0		
210  HandFinish Hand Finishing	HandFinishing Memo 1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: 1115796	0.00 0.00	1014115			x4	x4		
220  QC Quality Control	QC3 Inspect part completeness to step on W/O  Memo	0.00 0.00				4			 10-11-16

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 10/15/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230



Packaging

Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

0.00

240



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

62750 10/11/16 SRTX4

CK 10/11/16

mtf 10-11-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Parent Item: D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM□□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960C10L	<u>NAS1149C0332</u> R	Purchased	No			100	Each	29.0000	3	12			



washer

NAS115832



x12 10/11/15

Location

Loc Qty

Loc Code

ST245

29

107534

29

D2622-120C

Manufactured

No

110

Each

156.4200

1

4



Step Extrusion



10.11.02

Location

Loc Qty

Loc Code

WA

156.42

55214

3.42

58544

25

61208

128

D2734

Manufactured

No

110

Each

65.0000

2

8



Step End Plate



10.11.10

Location

Loc Qty

Loc Code

WA

65

60216

5

61209

60

D3459-1

Manufactured

No

110

Each

26.0000

2

8



Float Step Mounting Plate



10.11.03

Location

Loc Qty

Loc Code

WA

26

61213

26

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 2

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Parent Item: D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

D3459-3 Manufactured No

210 Each

30.0000

2

8



Float Step Mounting Plate

Location

Loc Qty

Loc Code

WA

30

61214

12

62396

18

MS27039C1-07 Purchased No

210 Each

67.0000

3

12



screw

Location

Loc Qty

Loc Code

ST293

67

111424

3

115460

64

1115460

NAS1329C3KB130 Purchased No

210 Each

76.0000

3

12



insert

Location

Loc Qty

Loc Code

ST276

76

111981

30

115719

46

NAS1515H3L Purchased No

210 Each

380.0000

3

12



WASHER

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

340

111819

94

113362

246

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Shop Packet Print

Page 2

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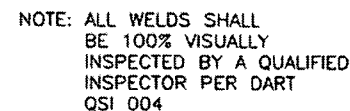
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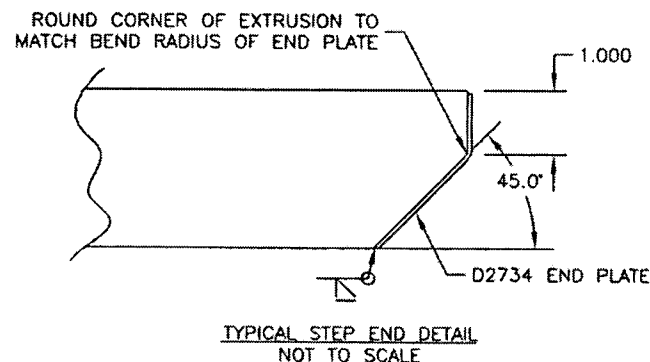
DART

SECRET

DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D2842	REV. B SHEET 1 OF 1
DATE 05.09.23		TITLE 206L/407 FLOAT STEP ASSEMBLY NTS SCALE	
A	98.10.13	NEW ISSUE	
B	05.09.23	RE-DESIGN, ADD D3459-1/-3	



QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2642-041	LH STEP ASSEMBLY
	X	D2642-042	RH STEP ASSEMBLY
1	1	D2622-11B	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS13Z9C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN950C10L	WASHER



- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05-11-14

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